

MARCH 2

Work Order ID 130242

130242

Page 1

Friday, February 27, 2015 4:19:06 PM

Item ID: D3574-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Floor Protector

Start Date: 2/26/15

Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/03/15

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date: 15-2-27

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574

Dwg Rev: B

Prog Rev: B

2-Deburr

2 0 JM15-3-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2 0 JM15-3-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(2)

MAR 02 2015

130

130

Small Fab

Small Fab

Small Fab

Memo

Debur if necessary.

N/A

DAS 0.00

38

9-89 0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

N/A

DAS 0.00

38

9-89 0.00

DQA: _____ Date: _____



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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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N900040100

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NS1

Revision ID:

Stop

NS2

Item Name: Cabin Floor Protector

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Start Qty: 2.00

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Cust Item ID:

Required Date: 3/03/15

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

DAG
03
3-09

MAR 02 2015

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MJ 150303

MS-3-3

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, February 27, 2015 4:19:06 PM

Page 1

Work Order ID: 130242

130242

Parent Item: D3574-2

D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 2/26/15

Required Date: 3/03/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04

Purchased

No

sf

1,134.134

51

MI FXS 125-F60029-04

Jm15-3-2

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT019

1134.1344

m129759

110.3334

m130209

1023.801

130209.

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	<u>130242</u>
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003"	-		✓	Jkmo1
7.37	+/-0.030	7.37"	-		✓	
10.75	+/-0.030	10.75"	-		✓	
11.00	+/-0.030	11.00"	-		✓	
15.25	+/-0.030	15.25"	✓		✓	
25.87	+/-0.030	25.87"	✓		✓	
39.75	+/-0.030	39.75"	✓		✓	
44.75	+/-0.030	44.75"	-		✓	
53.51	+/-0.030	53.51"	-		✓	
63.50	+/-0.030	63.50"	-		✓	
65.25	+/-0.030	63.25"	-		✓	
10.75	+/-0.030	10.75"	-		✓	
11.00	+/-0.030	11.00"	-		✓	
14.75	+/-0.030	14.75"	-		✓	
25.50	+/-0.030	25.50"	-		✓	
25.75	+/-0.030	25.75"	-		✓	
26.00	+/-0.030	26.00"	-		✓	
32.87	+/-0.030	32.87"	-		✓	
38.81	+/-0.030	38.81"	-		✓	
45.00	+/-0.030	45.00"	-		✓	
48.25	+/-0.030	48.25"	-		✓	
58.38	+/-0.030	58.38"	-		✓	
61.25	+/-0.030	61.25"	-		✓	
64.13	+/-0.030	64.13"	-		✓	
64.63	+/-0.030	64.63"	-		✓	
66.50	+/-0.030	66.50"	-		✓	
7.50	+/-0.030	7.50"	-		✓	
9.50	+/-0.030	9.50"	-		✓	
10.38	+/-0.030	10.38"	-		✓	
10.88	+/-0.030	10.88"	-		✓	
14.50	+/-0.030	14.50"	-		✓	
16.56	+/-0.030	16.56"	-		✓	
18.75	+/-0.030	18.75"	✓		✓	
24.13	+/-0.030	24.13"	-		✓	

DART AEROSPACE LTD		Work Order:	
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50"	-		T	
30.50	+/-0.030	30.50"	-		T	
33.88	+/-0.030	33.88"	-		T	
39.50	+/-0.030	39.50"	-		T	
40.25	+/-0.030	40.25"	-		T	
43.50	+/-0.030	43.50"	-		T	
46.60	+/-0.030	46.60"	-		T	
7.63	+/-0.030	7.63"	-		V	
11.00	+/-0.030	11.00"	-		T	
11.50	+/-0.030	11.50"	-		T	
16.75	+/-0.030	16.75"	-		T	
19.00	+/-0.030	19.00"	-		T	
22.50	+/-0.030	22.50"	-		T	
30.75	+/-0.030	30.75"	-		T	
32.63	+/-0.030	32.63"	-		T	
32.75	+/-0.030	32.75"	-		T	
35.13	+/-0.030	35.13"	-		T	
36.50	+/-0.030	36.50"	-		T	
40.00	+/-0.030	40.00"	-		T	
41.88	+/-0.030	41.88"	-		T	
43.63	+/-0.030	43.63"	-		T	
0.125	+/-0.010	0.125"	-DAS		V	

Measured by: JM	Audited by: 9-89	Prototype Approval:	N/A
Date: 15-3-2	Date: MAR 12 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

